

Ship Sept. 12

Dart Aerospace Ltd.

37
45

Date: Friday, 17/08/2007 11:10:39 AM
User: Linda Lacelle











Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR ASSEMBLY
Job Number : 34053B	
Estimate Number : 12509	
P.O. Number : N/A	Part Number : D206746043
This Issue : 17/08/2007 S.O. No. : N/A	Drawing Number : DSI9341
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 32031B	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 11/09/2007 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature]</u> 07.08.20	
Comment : est rev A 06.08.21 New Issue EC	
Est rev B 07.03.15 DSI 9341 Rev B KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3471041	BLOWER MOTOR SUPPORT
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) BLOWER MOTOR SUPPORT Batch: <u>B 34066</u>		
2.0	D3473041	BLOWER INLET ADAPTER
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) BLOWER INLET ADAPTER Batch: <u>B 32034</u>		
3.0	D3476041	blower motor adapter
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) blower motor adapter Batch: <u>B 34439</u>		
4.0	D3477041	Blower Motor Inlet Adapter
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Blower Motor Inlet Adapter Batch: <u>B 31258</u>		
5.0	D35851	SET SCREW
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) SET SCREW <u>B 31384</u>		

(P10) →

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-09-10	9	Added lockwire around screws to set MS20995-25E. Add to estimate perm. change	MF	07-09-10	1		En Stodu	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/09/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:10:40 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ASSEMBLY

Job Number: 34053B

Part Number: D206746043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	26D71	Blower Motor
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

JANITROL BLOWER MOTOR ASSEMBLY

Batch: m104032

mf

7.0	AN33A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

Batch: m104291

mf

8.0	AN96010	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

Batch: m5519

mf 02-09-11

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Center punch set-screw, then drill as per dwg.

Assemble as per dwg DSI 9341

Add locktite 26221 to fan set screw batch: m102855

mf 07-09-11

(MADLO)

10.0	QC5	INSPECT WORK TO CURRENT STEP
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to KD Pan.



Comment: INSPECT WORK TO CURRENT STEP

Er 07-9-12 (41)

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-746-043

Location: _____

PPP Rev: _____

07/5/13 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AP Date: 07/09/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:10:40 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ASSEMBLY

Job Number: 34053B

Part Number: D206746043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

D07109/13

Job Completion



U A109-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9341	REV. B SHEET 1 OF 2
DATE 07.01.02		TITLE BLOWER MOTOR ASSEMBLY SCALE NTS	
REV A	DATE 06.08.09	DESCRIPTION NEW ISSUE	
B	07.01.02	ADD D3585-1 & DETAIL B	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-746 REV.A

REF. CANADIAN STC: SH05-45 ISSUE 1

FAA STC: SH3367NM DATED OCT. 13, 2005

The Parts List of Installation Instructions IIN-D206-746 Rev. A should be amended as follows:

Qty -011	Qty -041	Qty - 043	Part Number	Description
X			D206-746-011	SHROUD AIRFLOW HEATER SYSTEM
1	X		D206-746-041	REAR OVERHEAD PASSENGER MODIFICATION KIT
1		X	D206-746-043	BLOWER MOTOR ASSEMBLY
		1	D3471-041	BLOWER MOTOR SUPPORT (CAM-1984-008)
		1	D3473-041	BLOWER INLET ADAPTER (CAM-1984-013)
		1	D3476-041	BLOWER MOTOR ADAPTER (CAM-1984-014)
		1	D3477-041	BLOWER MOTOR INLET ADAPTER (CAM-1984-015)
		2	D3585-1	SET SCREW
		A/R	26221	LOCTITE 226 THREADLOCKER
		1	26D71	BLOWER MOTOR (26D71-1)
		6	AN3-3A	BOLT
		6	AN960-10	WASHER
		3	MS27039-08-04	MACHINE SCREW
		3	MS35333-38	LOCK WASHER
		A/R	MS20995-025E	LOCK WIRE

Furthermore, any mention of "Blower Motor Assembly" appearing in Installation Instructions IIN-D206-746 Rev. A, and Installation Drawing D206-746 Rev. A, should be replaced by D206-746-043 Blower Motor Assembly.

For assembly instructions of D206-746-043 Blower Motor Assembly, refer to page 2 of this DSI.

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WORK ORDER
NO. 34053 B

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

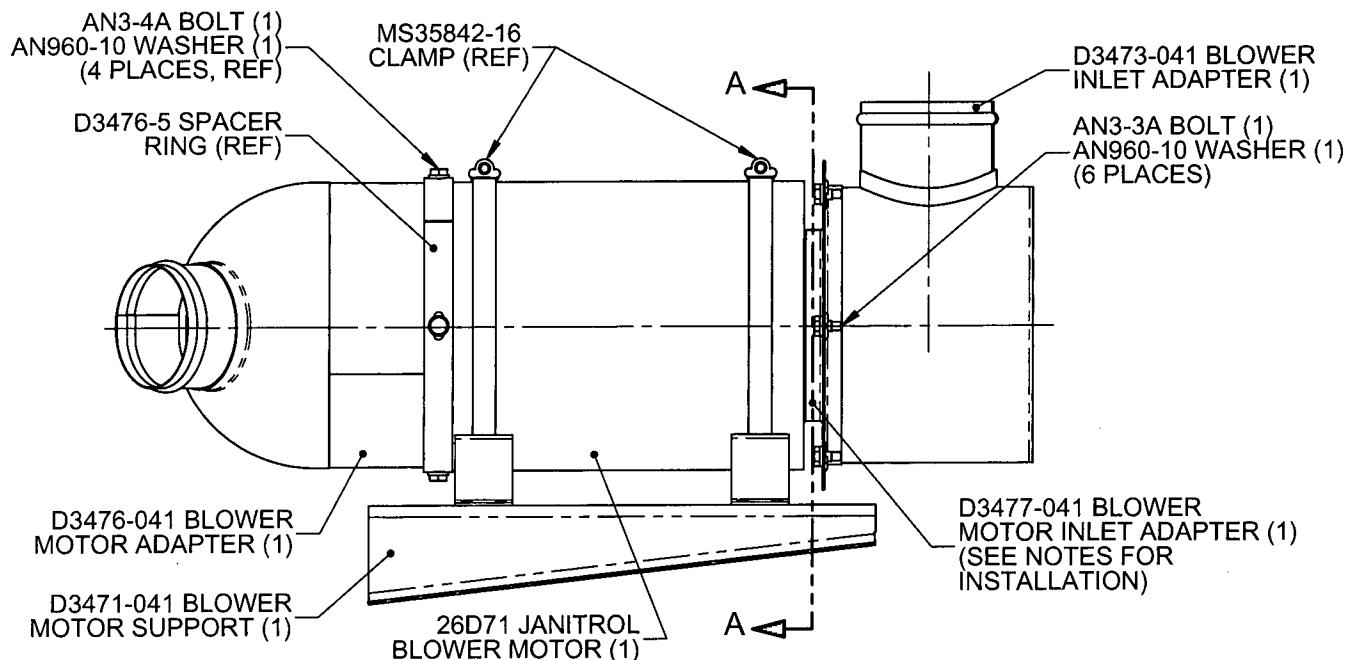
DATE: 07.01.02
CERT. NO.: SH05-45
ISSUE NO.: 1

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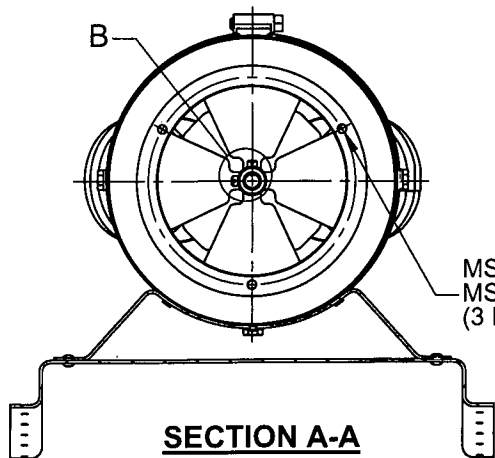
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. DSI 9341	REV. B SHEET 2 OF 2
DATE 07.01.02		TITLE BLOWER MOTOR ASSEMBLY	SCALE 1:4

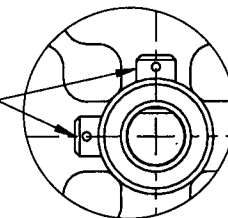


D206-746-043 BLOWER MOTOR ASSEMBLY



SECTION A-A

REPLACE EXISTING SET SCREWS
WITH D3585-1 SET SCREWS (2),
APPLY LOCTITE 226, TORQUE TO
50-70 in-lbs (5.6-7.9 N-m) AND SECURE
USING MS20995-025E LOCK WIRE



DETAIL B
SCALE 1:1

NOTES:

- 1) ON 26D71 BLOWER MOTOR, REMOVE EXISTING MACHINE SCREWS (3), LOCK WASHERS (3) AND EXISTING ADAPTER (1).
- 2) REPLACE ADAPTER WITH D3477-041 BLOWER INLET ADAPTER. USE HARDWARE REMOVED AT STEP 1 TO SECURE D3473-041 BLOWER INLET ADAPTER TO 26D71 JANITROL BLOWER MOTOR.
- 3) D206-746-043 IS SUPPLIED TO CUSTOMER PRE-ASSEMBLED.

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APPROVED	
BY: <i>D. Shepherd</i>	D. SHEPHERD (DE # 02)
DATE: 07.01.02	
CERT. NO.: SH05-45	
ISSUE NO.: 1	

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